

Date: Thursday, 11/23/2006 11:56:32 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29678
 Estimate Number : 10578
 P.O. Number : N/A
 This Issue : 11/23/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 28211
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : A 05.09.27 New issue EC

Drawing Name : CLEVIS
 Part Number : D34533
 Drawing Number : D3453 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 12/5/2006

Qty: 15 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304R1250 Inventory



Comment: Qty.: 0.2452 f(s)/Unit Total : 1.4712 f(s)
 Material: AISI 304 SS Round Bar Ø1.250
 (M304R1.250)
 Batch: 101549

J.F. 06/12/05 (15)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 1-Turn as per Folio FA578 Rev: AA & Dwg D3453 Rev: A
 2- Deburr as per dwg D3453

J.F. 06/12/05 (15)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/05 (15)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Mill as per Folio FA578 Rev: AA & Dwg D3453 Rev: A
 2- Deburr as per dwg 3453

J.L./J.F. 06/12/12 (13)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

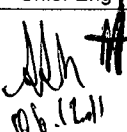

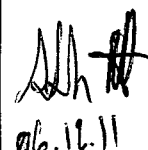
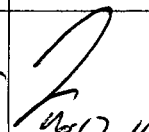
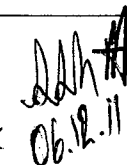
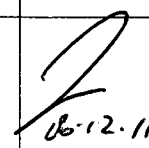
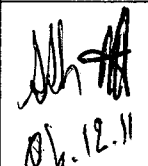
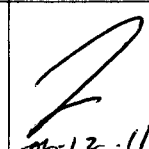


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L./J.F. 06/12/12 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/12/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-12-11	4.0	Depth of the slot should be 1.175, and 1.175 is 1.195.	 06.12.11	Part acceptable	J.L. 06/12/11	 06-12-11	 06.12.11	 06-12-11
06-12-11	4.0	2 parts scrap. 1- part offset was wrong, part off by .060. 2- the -(neg) adjustment took off too much mat'l on the inside.	 06.12.11	Scrap; no replace, destroy	J.L. 06/12/11	 06-12-11	 06.12.11	 06-12-11

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:56:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 29678

Part Number: D34533

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3453

2-Deburr as per dwg D3453

J.F / DSP 06/12/16

(13)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F / DSP 06/12/16

(13)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G 06/12/18

(13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57437

P 06/12/18

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/19 (13)

Job Completion



C 20612118

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29678
Description: Clevis		Part Number:	D3453-3
Inspection Dwg: D3453 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article ☐ Prototype

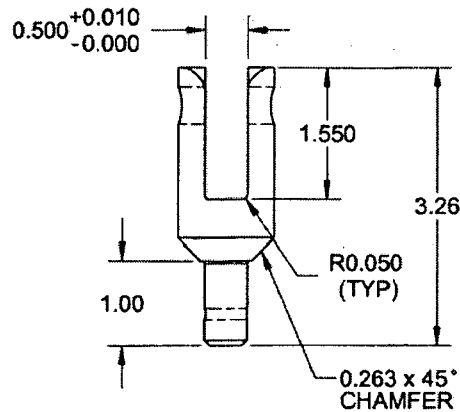
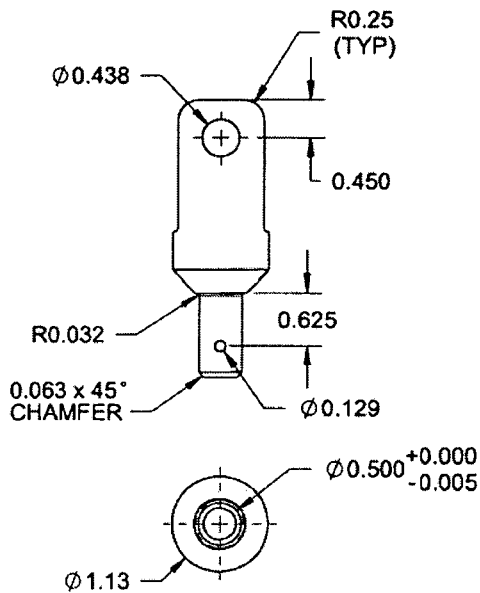
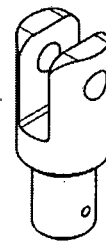
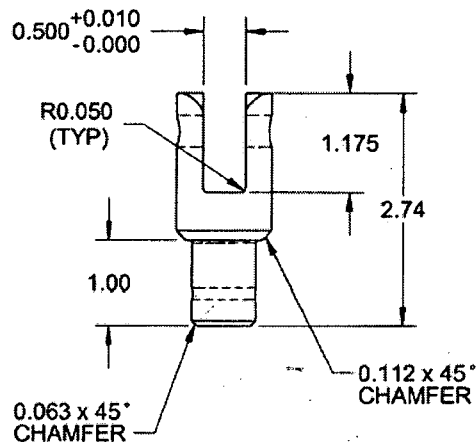
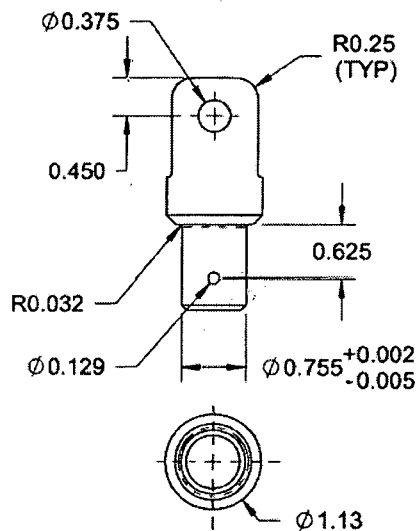
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+0.012/-0.001	1.131	✓			
Ø0.755	+0.002/-0.005	.751	✓			
2.74	+/-0.030	2.737	✓			
1.175	+/-0.010	1.170	✓			
1.00	+/-0.030	1.005	✓			
0.500	+0.010/-0.000	.504	✓			
Ø0.375	+0.006/-0.001	.380	✓			
Ø0.129	+0.005/-0.001	0.129	✓			
0.625	+/-0.010	0.623	✓			
0.450	+/-0.010	.452	✓			

Measured by:	J.F. / J.L.	Audited by:		Prototype Approval:	N/A
Date:	06/12/05	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**05.12.09 **D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

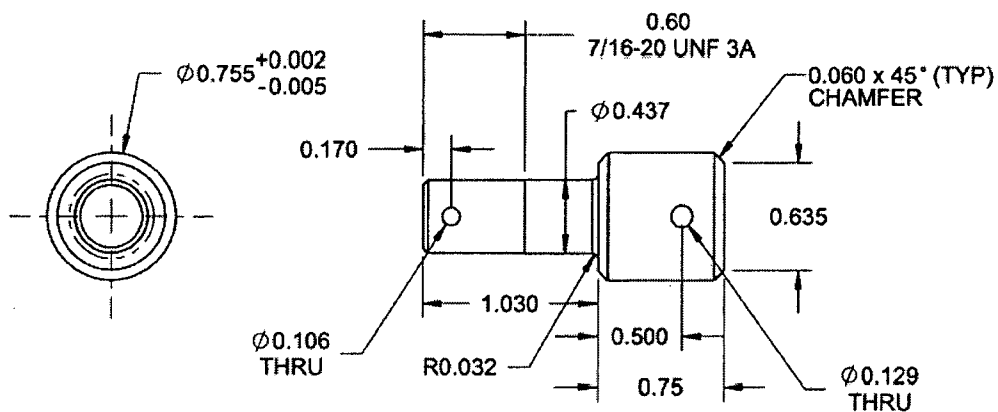
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:1

RELEASED05.12.09 *[Signature]***D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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